

Work Order ID 54929

January 4, 2010 1:57:16 PM

Page 1

Item ID: D2571

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, Fwd Out 205

Start Date: 1/04/10 Start Qty: 8.00

Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2571

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 54929 Double check by: *DP* 11-Machine Step No 1
per Folio FA051 and inspect per attached Dimension Sheets 12-Machine Step
No 2 per Folio FA051 and inspect per attached Dimension Sheets 13-Machine
Step No 3 per Folio FA051 and inspect

MMJ
DP
10/01/09

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

DP
10/01/10

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DP
10/01/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

9:15am

OVEN TEMPERATURE:

9:45am FINISH TIME:

320°F

SP 10/21/11

PR 10-01-12

7/4 10/01/12

8 0

8

✓

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54929

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Page 3

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Setup Start



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Item Name: Saddle, Fwd Out 205

Start Date: 1/04/10 Start Qty: 8.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR

10-01-12

8

8

170

Identify as per dwg & Stock Location: 433

0.00



Packaging

Memo

0.00

Packaging

10-1-12

8x

8

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/13

MF 10-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 4, 2010 1:57:15 PM

Page 1

Work Order ID: 54929



Parent Item: D2571

Parent Item Name: Saddle, Fwd Out 205

Start Date: 1/04/10

Required Date: 1/15/10

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D6101-007

Manufactured

No

100

Each

82.0000

8.0000



Saddle Billet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

82

41960

1

46412

81

8
10/01/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	54924
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.746	1.747	1.747	1.748		
C	3.495	3.505		3.495	3.495	3.495	3.496		
D	1.745	1.755		1.746	1.746	1.746	1.746		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		0.498	0.497	0.497	0.499		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.498	0.497	0.498	0.497		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.5645	0.564	0.565	0.564		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.128	0.128	0.129	0.129		
Q	0.115	0.135		0.130	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.255	0.253	0.253		
S	0.115	0.135		0.130	0.135	0.128	0.128		
T	0.178	0.198		0.187	0.187	0.187	0.187		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.238	0.240	0.238	0.238		
W	0.115	0.135		0.124	0.123	0.124	0.124		
X	0.308	0.313		0.310	0.311	0.311	0.311		
Y	0.760	0.765		0.763	0.763	0.763	0.763		
Z	0.352	0.372		0.362	0.368	0.366	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.631	0.631	0.630	0.635		
AC	0.053	0.073		0.062	0.062	0.062	0.062		
AD	0.240	0.260		0.250	0.250	0.250	0.250		
AE	1.375	1.395		1.386	1.390	1.392	1.392		
AF	0.115	0.135		0.135	0.130	0.135	0.135		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.248	0.250	0.247	0.247		
AI	2.000	2.020		2.005	2.005	2.005	2.005		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	DTA
Date:	10/01/09

Audited by:	SP
Date:	10/01/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 54929
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

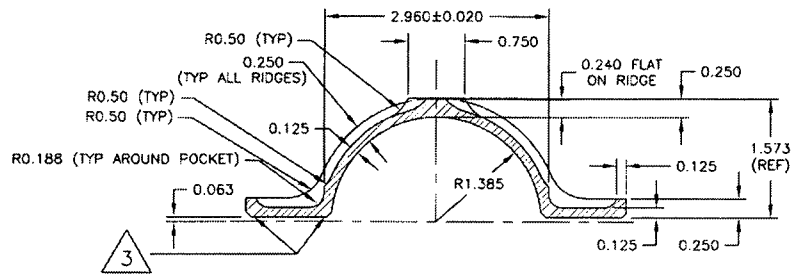
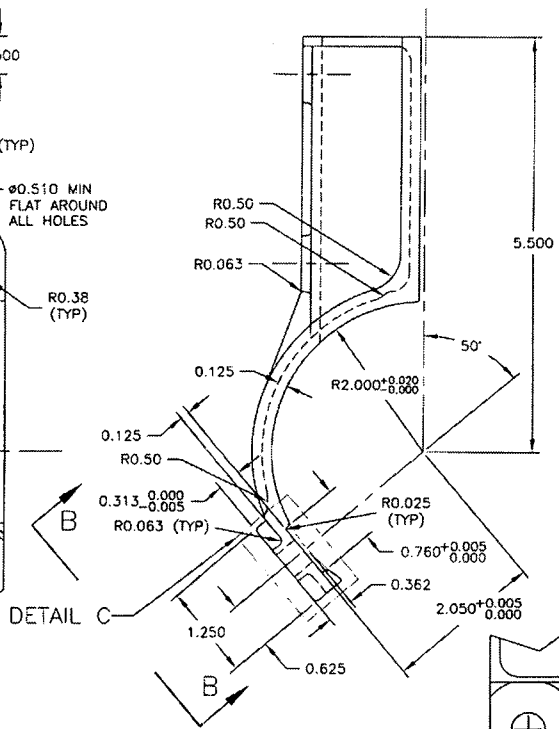
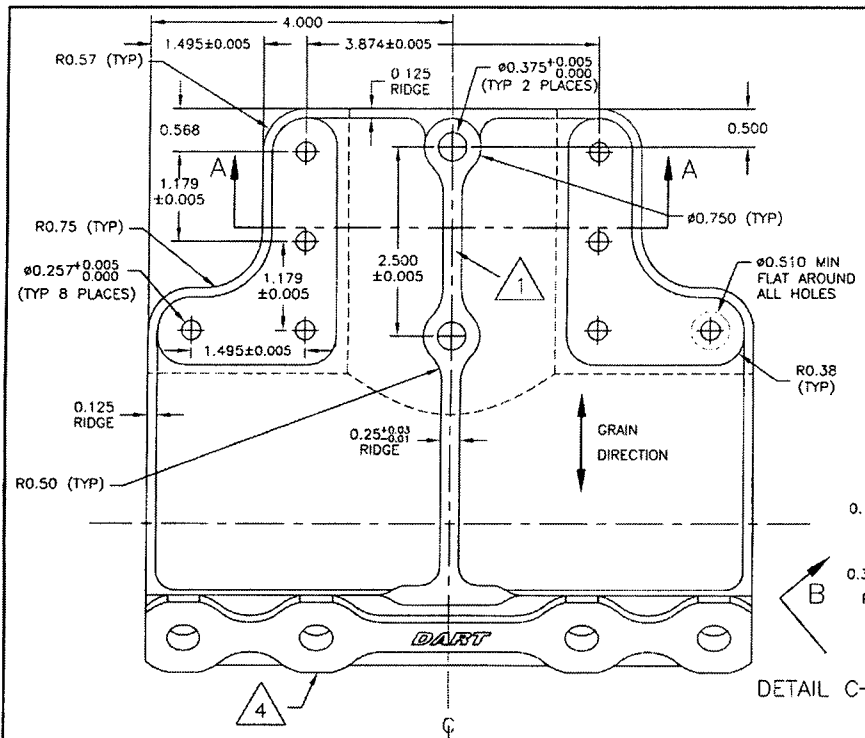
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.748	1.748	1.748	1.748		
C	3.495	3.505		3.496	3.496	3.496	3.496		
D	1.745	1.755		1.746	1.746	1.746	1.746		
E	7.990	8.010		8.004	8.004	8.004	8.004		
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R	0.240	0.260		0.252	0.253	0.253	0.2535		
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AB	0.615	0.635		0.635	0.635	0.635	0.635		
AC	0.053	0.073		0.062	0.062	0.062	0.062		
AD	0.240	0.260		0.255	0.252	0.250	0.255		
AE	1.375	1.395		1.3895	1.389	1.389	1.391		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.247	0.249	0.249	0.247		
AI	2.000	2.020		2.002	2.005	2.001	2.004		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 10/01/10	Date: 10/01/11

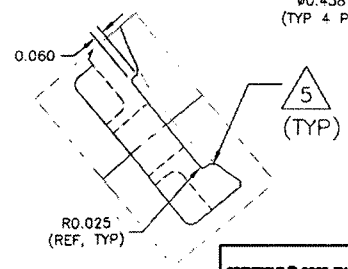
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D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

also 54929

RELEASED
05-26-11



SECTION A-A

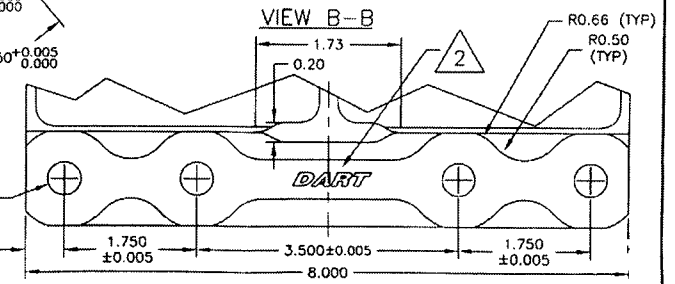


DETAIL C
SCALE 4:3

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES: TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO. D2571
		TITLE OUTER FWD SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:3

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